

Date: Tuesday, 8/1/2006 11:23:29 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : OH-58 STEP ASSY LH *UNDER REVIEW**
 Job Number : 28049
 Estimate Number : 12438
 P.O. Number : N/A Part Number : D058677011
 This Issue : 8/1/2006 S.O. No. : N/A Drawing Number : D2943 UNDER REVIEW
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : UNDER R
 Previous Run : 27398 Material : N/A
 Written By : Due Date : 8/31/2006 Qty: 2 Um: Each
 Checked & Approved By : 06.08.02
 Comment : Est Rev:B 01.04.11 Combined with D2943-041 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD058-677-011 CHG 001

06.08.04 KS.

2.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Extrusion D2622-120C
 Batch: B27077

06.08.16

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
 D2734 206 Step Endplate
 Batch: B27281

06.08.16

4.0 D2725 206 Step Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 D2725 206 Step Lug
 Batch: B20783

06.08.16

5.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2943-1 from D2622 extrusion as per Dwg D2943

2-Deburr and bevel ends for welding

3-Weld end cap(1) and plate as per Dwg D2943 using Jig DT 8482

06.08.16
 06.08.16
 06.08.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
					2		

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Drawing Name: OH-58 STEP ASSY LH *UNDER REVIEW**

Job Number: 28049

Part Number: D058677011

Job Number:



Seq. #:

Machine Or Operation:

Description:

A/R AL ROD

Batch: M156660

4-Grind end cap welds flush as per dwg D2943

RE. 06.08.16 2

6.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

11/06/08/23 (2)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06:08:25 (2)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

RE. 06.08.30 2

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld last end cap(1) as per Dwg D2943 using Jig DT 8482

A/R AL ROD Batch: M15689

RE. 06.08.30 2

2-Grind end cap welds flush as per dwg D2943

RE. 06.08.30 2

10.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

11/06/08/31 (2)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Chemical Conversion Coat as per QSI 005 4.1

Q.m 06-08-31 (2)

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DL 06/09/01 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OH-58 STEP ASSY LH *UNDER REVIEW**

Job Number: 28049

Part Number: D058677011

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D2943 and QSI 005 4.4

Batch: M101662

A.M 06-08-31

(2)

14.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

16.0

D27311

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Mounting Lug

Batch: B20613

17.0

D27313

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Mounting Lug

B20614

18.0

D27315

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Mounting Lug

Batch: B23332

19.0

D27317

Mounting Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Mounting Lug

Batch: B22592

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 06/07/06

NOTE: Date & initial all entries

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Job Number: 28049

Part Number: D058677011

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN411A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Batch: M100793

21.0

AN412A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

M101291 / M101390 15mc

22.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Batch: M19085

P06/9/05 (2)

23.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

C206/09/05 (5)

24.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP Do58-677-011

Location:

PPP Rev: B

P06/9/05 (2)

25.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

P06/09/06

Job Completion



U 20-09-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

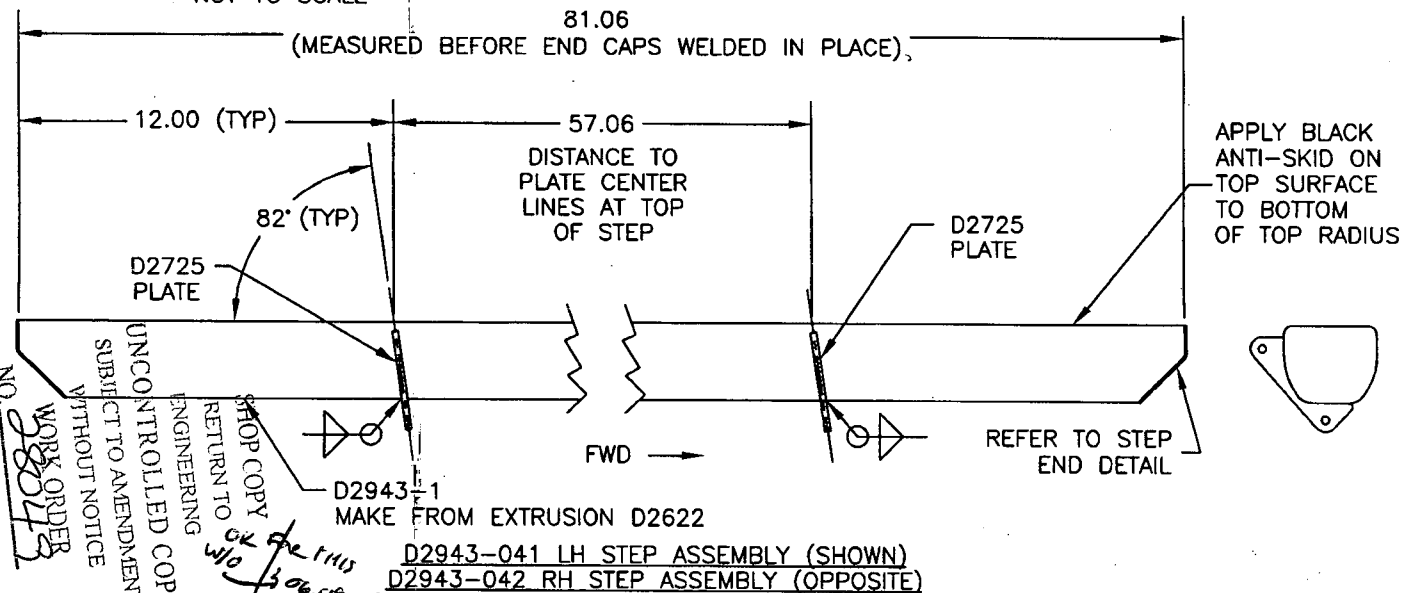
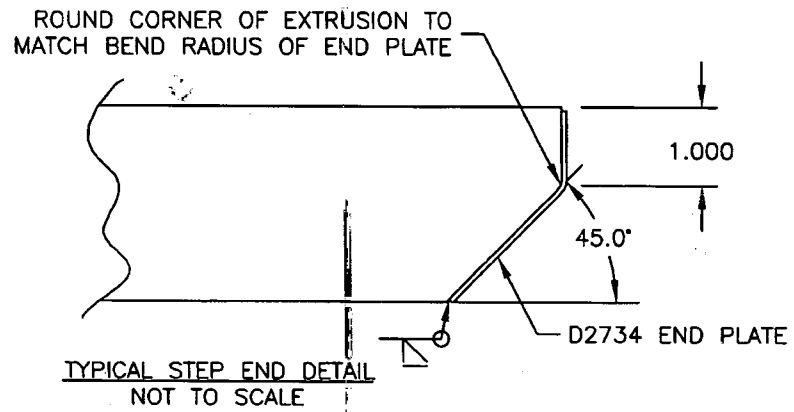
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN		DRAWN BY		DART AEROSPACE USA, INC.	
RF		RF		PORT HADLOCK, WA	
CHECKED		APPROVED		DRAWING NO.	REV. B
				D2943	SHEET 1 OF 1
DATE				TITLE	SCALE
05.11.14				OH-58 STEP ASSEMBLY	NIS
A				NEW ISSUE	
B				UPDATE FINISHING NOTE	

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



D2943-041/-042 OH-58 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
X	-041	D2943-041	LH STEP ASSEMBLY
X	-042	D2943-042	RH STEP ASSEMBLY
1	1	D2622-082*	EXTRUSION
2	2	D2725	PLATE
2	2	D2734	END PLATE

*cut per drawing

D2943-041/-042 OH-58 STEP ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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UNDER REVIEW
06-03-29 BH
RE-DESIGN
COMPARE TO 0206-638
RELEASED
05.11.28-180
OK FOR THIS W/O
10060602

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